

Work Order ID 83168

April-13-12 10:40:50 AM

83168

Page 1

Item ID: D2065

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Arm

Stop ***NS2***

Start Date: 13/04/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 27/04/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/04/13

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2065	Rev C

100 Small Fab 0.00

100

Small Fab

Small Fab

Memo

0.00

Small Fab

1-Punch 1/2" OD x .049" Wall 304/316 SS as per Dwg D2065 (per D2727) using DT8012.
Note: 1 end only
2-Cut to length as per Dwg D2065
3-Form as per Dwg D2065 and template DT8251
4-Drill 0.188" Dia holes as per Dwg D2065 using drill jig DT8779 and template

Wt at 19.625

6

Ø

FF

12-04-19

110 QC5- Inspect part completeness to step on W/O 0.00

110

QC

Memo

0.00

Quality Control

5/7/14/19

(46)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 83168

83168

Page 2

April-13-12 10:40:50 AM

Item ID: D2065

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Arm

Start Date: 13/04/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 27/04/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00

120

Powdercoat

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

8-15 0.00
320 OF
8-45

6x 0

m-f
12/04/23

Powder Coating

130

QC3- Inspect Part Finish

0.00

130

QC

Memo

0.00

6 0

12/4-23

Quality Control

140

Identify as per dwg & Stock Location: 229

0.00

140

Packaging

Memo

0.00

62

12/4/23

Packaging

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 83168***83168***

Page 3

April-13-12 10:40:50 AM

Item ID: D2065

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Arm

Start Date: 13/04/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 27/04/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC21- Final Inspection - Work Order Release

0.00

150

QC

Memo

0.00

Quality Control

12/4/24
ME
12-04-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April-13-12 10:40:54 AM

Page 1

Work Order ID: 83168

83168

Parent Item: D2065

D2065

Parent Item Name: Arm

Start Date: 13/04/2012

Required Date: 27/04/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP: E02.04.15Added Dwg Rev.B1NG
IPP Rev:F 08-07-24 revC as per dwg (ecn 08-504) DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TR0.500W.049		Purchased			No	120	f	276.4131	1.7	10.73684			

M304TR0 500W 049

304 RD Tube .500 x .049W

**

FF 12-04-18

Location

Loc Qty

Loc Code

MAT017

276.413058

111814

2.23

115010

109.254058

117598

3.97

119087

7.359

120633

153.6

10.73684

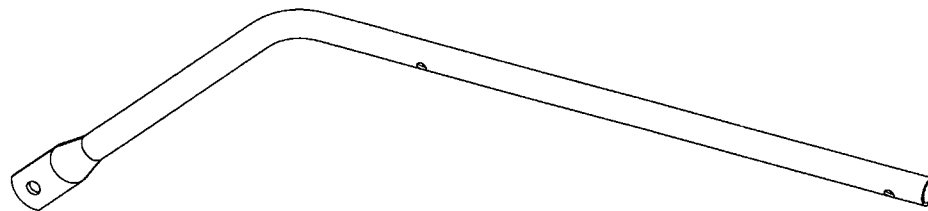
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D2065 ARM

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

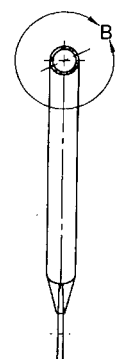
NO. 83168 MLJ
12/04/13

RELEASED
08-07-25-117

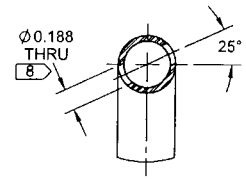
C	REDRAWN IN SOLIDWORKS; INCORPORATED REV. B1 (FINISH ADDED VIA HAND CHANGE) (ZN A8-2); ADD D2065F CUT LENGTH DETAIL FOR D2065 (ZN B3-2); ADD R1.50 DIMENSION (ZN D5-2); Ø0.500 X 0.049 WALL WAS Ø0.500 X 0.035 WALL (ZN A5-2); REASON: Ø0.500 X 0.035 WALL TUBING USED ON D2010 IS CRACKING DURING SERVICE	PH	08.06.13
B	RE-DESIGN	BW	96.02.06
A	NEW ISSUE	BW	92.03.12
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD	
DRAWN	PH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	IS	DRAWING NO.	REV. C
MFG. APPR.	IS	D2065	SHEET 1 OF 2
APPROVED	IS	TITLE	SCALE
DE APPR.	IS	ARM	NTS
DATE	08.06.13	COPYRIGHT © 1992 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1

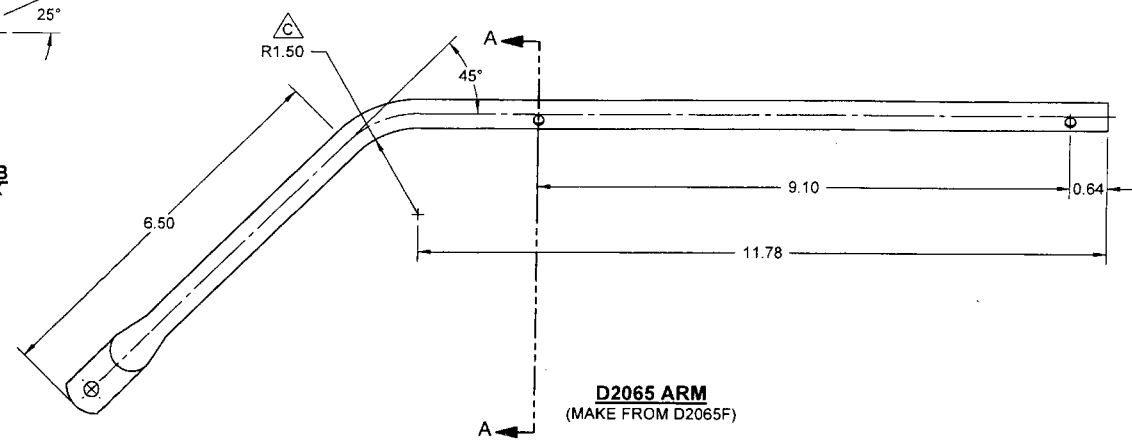
83168



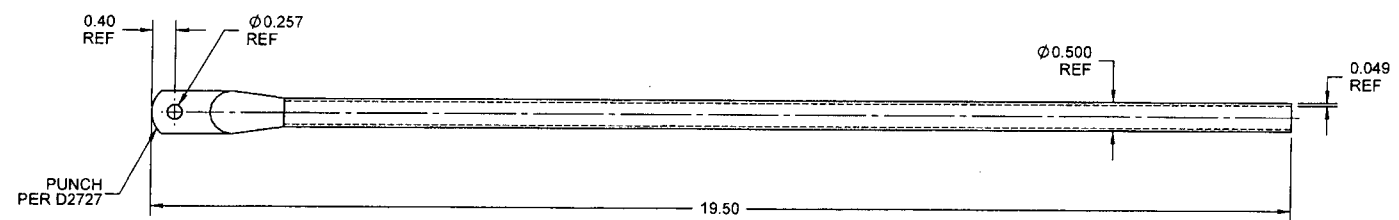
SECTION A-A



DETAIL B
SCALE 3X
2 PL



D2065 ARM
(MAKE FROM D2065F)



D2065F ARM CUT LENGTH DETAIL

NOTES:

- 1) MATERIAL: D2065F, AISI 304/316 SS SEAMLESS ROUND TUBING, $\phi 0.500 \times 0.049$ WALL (REF DART SPEC M304TR0.500W.049)
- 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.41 lbs
- 8) DRILL $\phi 0.188$ AFTER BENDING

DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	PH		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D2065	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		ARM	NTS
DATE	08.06.13	COPYRIGHT © 1992 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

RELEASED
08.07.2018

8 7 6 5 4 3 2 1